



**Work Order ID 68087**

Wednesday, April 06, 2011 11:38:45 AM

Page 2

Item ID: D206-667-247TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Ass'y

Start Date: 4/6/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

**Work Order ID 68087**

Wednesday, April 06, 2011 11:38:45 AM

Page 3

Item ID: D206-667-247TRN

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Ass'y

Start Date: 4/6/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-4-9

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: 46

11-4-9

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-04-21  
11-04-21

POSITIVE RECALL

EFFECTIVE 11/04/06 AUTH   
RELEASED DATE 11/05/2511/5/3008  
11-05-27

# Picklist Print

Wednesday, April 06, 2011 11:38:43 AM

Page 1

Work Order ID: 68087



Parent Item: D206-667-247TRN



Parent Item Name: Crosstube Ass'y


Start Date: 4/6/2011

Required Date: 4/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115  Crosstube Material		Manufactured	No			100	Each	35.0000	1	1		11.4.11	

Location

Loc Qty

Loc Code

LG

35

34685

6

38336

29

DART AEROSPACE LTD		Work Order: 18187
Description:		Part Number: 206-667-247
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.490	+0.05 - 0.0	2.495	/		Rq. 02	
2.025	+0.05 - 0.0	2.029	/			
2.079	+0.05 - 0.0	2.083	/			
2.145	+0.05 - 0.0	2.150	/			
2.209	+0.05 - 0.0	2.214	/			
2.287	+0.05 - 0.0	2.292	/			
2.363	+0.05 - 0.0	2.368	/			
.200	+/- .010	.200	/		Rq. 02	
R.063	+/- .010	.063	/			
4.438	+/- .030	4.438	/			
5.389	+/- .030	5.389	/			
R.2.00	+/- .030	R.2.00	/			
99.76	+/- .020	99.7600	/		Rq. 14	

Measured by: <i>AL</i>	Audited by: <i>SL</i>	Prototype Approval: <i>JP</i>
Date: 11-4-11	Date: 11/4/11	Date: 11-04-11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Item	Qty	Part Number	Description
	-247		
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 98.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**PRELIMINARY ISSUE**

Rev PA1 9/11.01.06

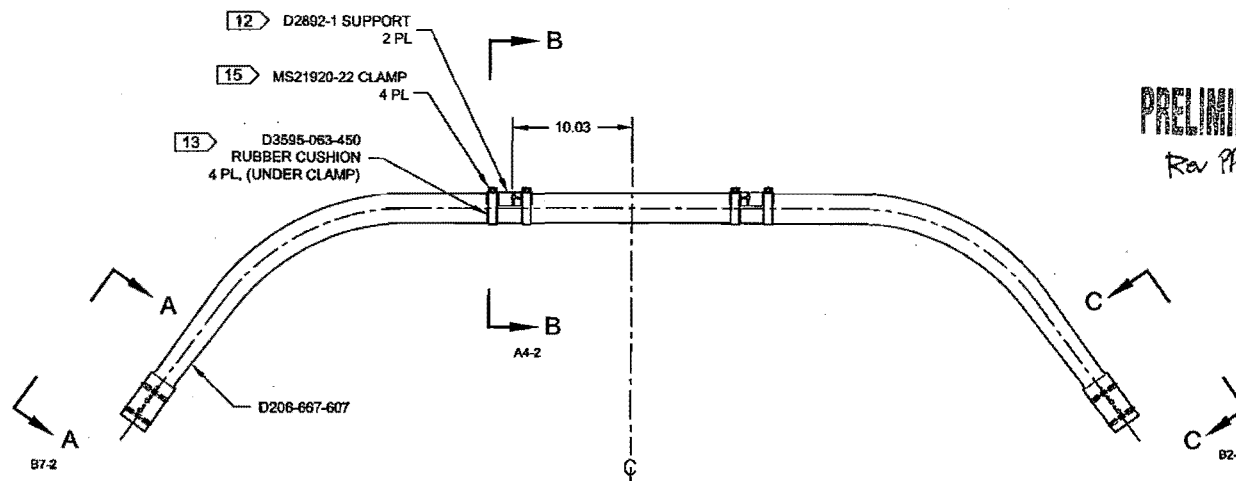
67087

REV.	NEW ISSUE	DESCRIPTION	CP	10.12.23
DESIGN	92	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	BY	DATE
DRAWN	92			
CHECKED	92	DRAWING NO.	REV. #	9/11
MFG. APPR.		D206-667-247		SHEET 1 OF 4
APPROVED		TITLE		SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)		NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

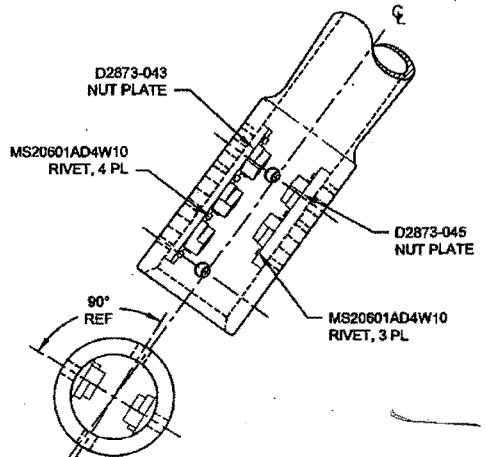
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**PRELIMINARY ISSUE**

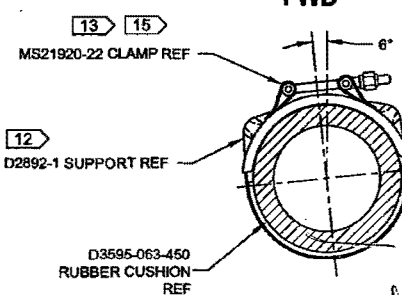
Rev PA1 11.01.06



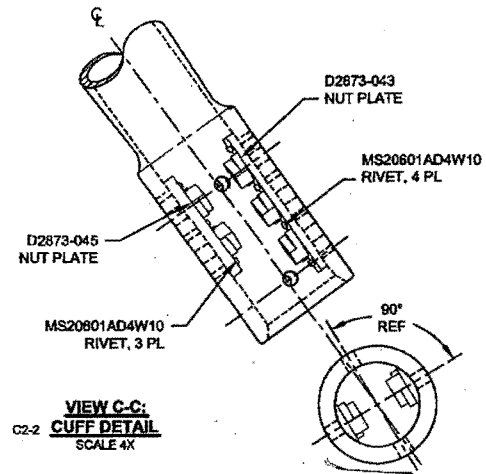
**D206-667-247  
 ASSEMBLY DETAIL  
 (VIEW LOOKING FWD)**



**VIEW A-A:  
 CUFF DETAIL  
 SCALE 4X**



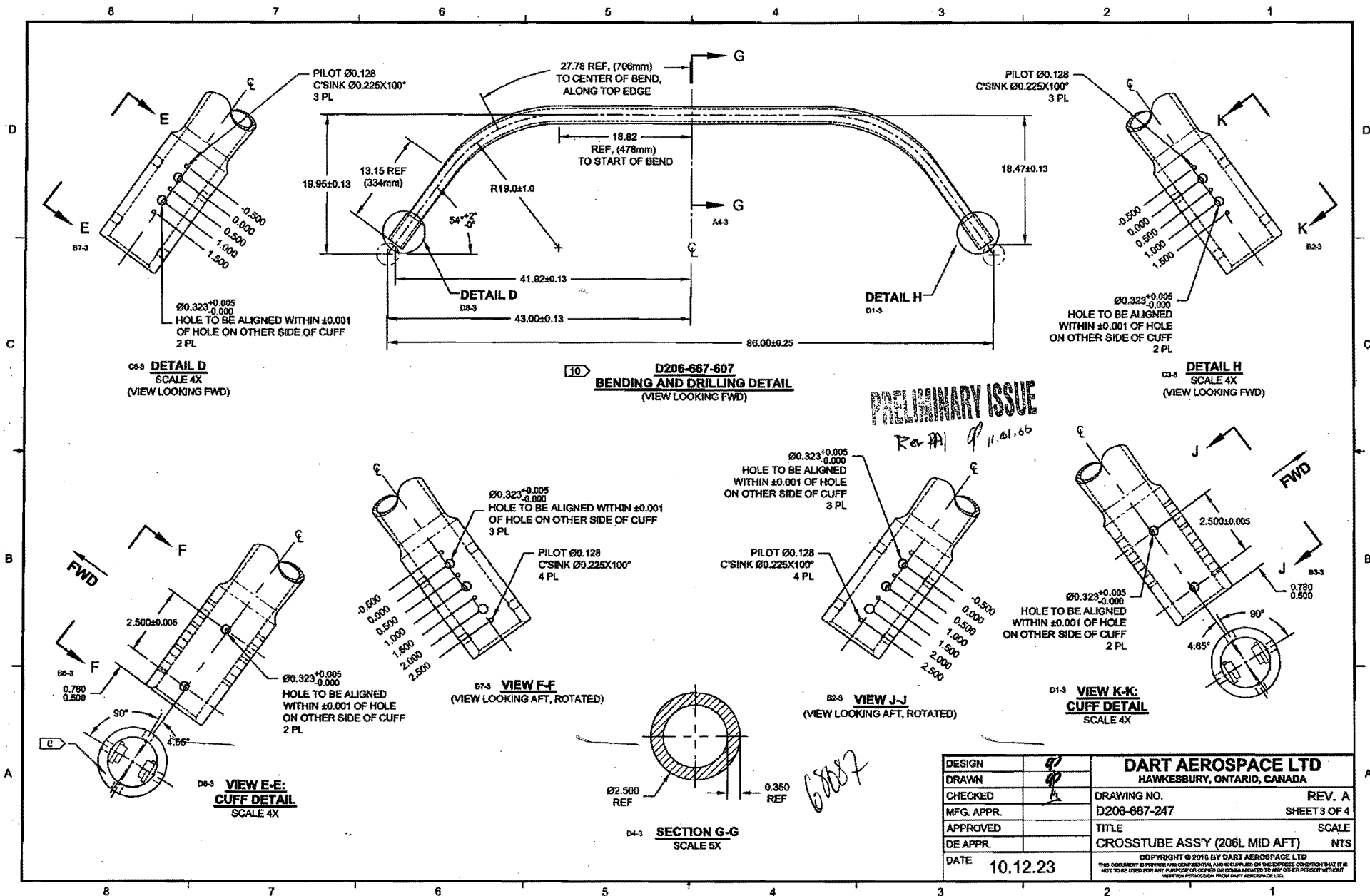
**SECTION B-B  
 SCALE 5X**



**VIEW C-C:  
 CUFF DETAIL  
 SCALE 4X**

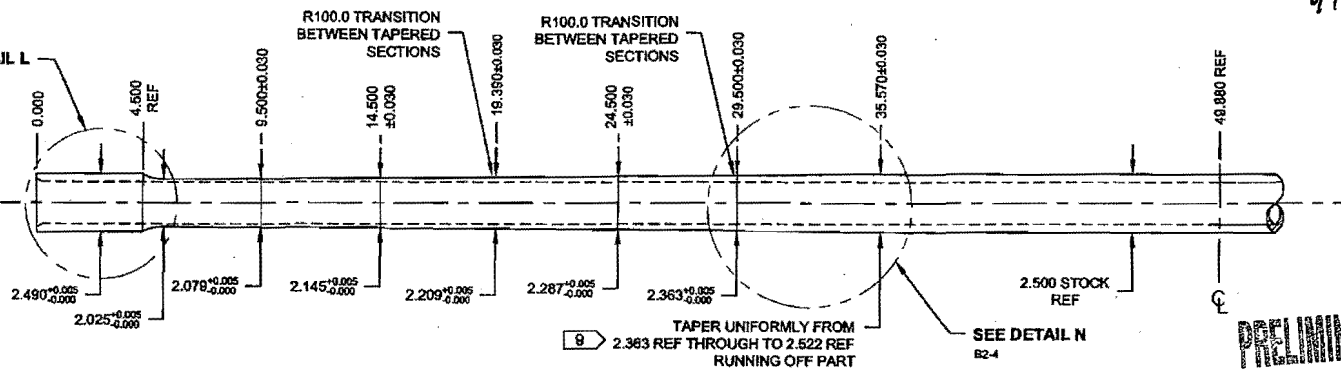
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DRAWN	47	HAWKESBURY, ONTARIO, CANADA	
CHECKED	47	DRAWING NO.	REV. 4
MFG. APPR.		D206-667-247	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)	NTS
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8 7 6 5 4 3 2 1





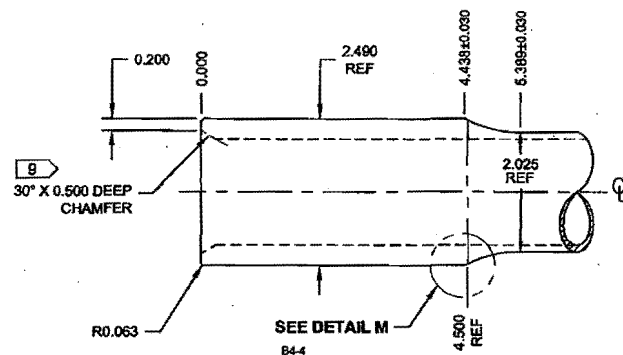
SEE DETAIL L  
B7-4



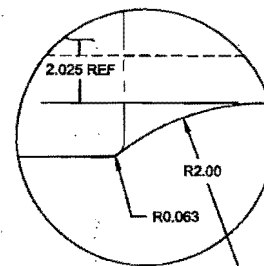
PRELIMINARY ISSUE

REV PAI 4/11.01.86

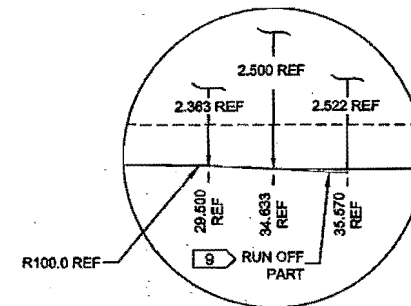
TURNING DETAIL



C7-4 DETAIL L: CROSSTUBE CUFF  
SCALE 2.5X



B6-4 DETAIL M: CUFF TRANSITION  
NOT TO SCALE



C4-4 DETAIL N: TAPER RUN-OFF  
NOT TO SCALE

DESIGN	99	<b>DART AEROSPACE LTD</b>	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.		D206-667-247	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSY (206L MID AFT)	NTS
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68087

Date: Friday, 9/14/2007 2:01:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSTUBE EXTRUSION (206L)
Job Number : 34685	
Estimate Number : 10027	
P.O. Number : N/A	Part Number : D6004115
This Issue : 9/14/2007 S.O. No. : N/A	Drawing Number : D6004 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : RMA	Drawing Revision : A
Previous Run : 32305	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 1/30/2008 Qty: 36 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev B 00.12.15 Added: Issue P/O EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O 4611C207/09/18

a) Extrude as per Dwg D6004

b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Material certification required

(36)

2.0

D6004115P

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 36.0000 Each(s)

Crosstube material

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

PC 8/01/03 (39)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6004

2 08/01/06 (435)

Date: Friday, 9/14/2007 2:01:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSTUBE EXTRUSION (206L)

Job Number: 34685

Part Number: D6004115

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*u/g*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MAT-24

*J.L 08/01/17*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(39)*

Comment: FINAL INSPECTION/W/O RELEASE

*D 08/01/18*

Job Completion



*2008/11/16*  
*U*

# BA TUBES LIMITED

Studley Road, Redditch, Worcestershire B98 7HN, England  
Telephone (01527) 484500, Facsimile (01527) 484501

Approved Certificate According to EN10204:2004

For all Customer and 3rd Party approvals  
visit [www.batubes.com](http://www.batubes.com)

No. C715

## Customer

DART AEROSPACE LIMITED  
1270 ABERDEEN STREET  
HAWKESBURY  
ONTARIO  
CANADA

K6A 1K7

## Your Order No

PO00004611

## Your Part No

D6004-115P

## Our Order No

94945/2

## Packing Note No

151441

## Date

30/11/07

## Packages

1 CASE

## Other Tests Passed

## Size / Description

SEAMLESS DRAWN TUBE 2.5 INS O/D 0.35 INS W/T 7075 Alloy  
Length - 115.08 inches

## Specification

7075 T6  
WW-T-700/7B

No of Pieces	Nett Weight Lbs	Tensile Test				Chemical Analysis %													
		Test No	0.2% Proof Stress KSI	Tensile Strength KSI	% Elongation 2in	Heat or Cast No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Zr				Ti
18	496	331212 LO	66.1	77.3	14	2N267	.09	.26	1.53	.04	2.58	.19	.01	5.85	.01				C
21	580	331214 LO	67.9	78.2	13	2N267	.09	.26	1.53	.04	2.58	.19	.01	5.85	.01				C
3																			

## Remarks

CASE NO.12976

ALLOY MELTED IN THE UNITED KINGDOM

Authorised Inspection Representative

Mr Terry Layton - For and on behalf of BA Tubes

In accordance with the RoHS directive,  
certify that the above mentioned product  
contains no banned or relevant substances

Mercury Free.

Registered in England No. 3981386  
Registered Office: The Victoria, 150-182 Harbour City  
Salford Quays, Salford, M50 3SP, England.  
VAT Registration No. GB 668 2142 86



A Luxfer Group Company

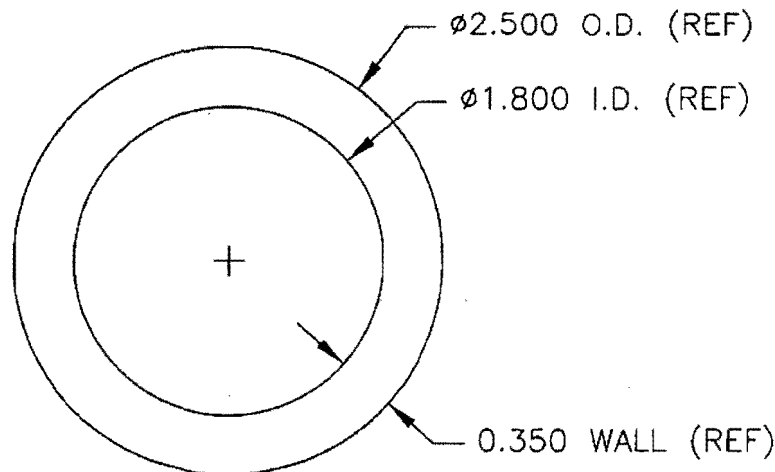
This certificate should not be reproduced other than in full, without the written approval of BA  
These results pertain only to the item(s) tested as samples by the client unless otherwise indicated



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6004	REV. A SHEET 1 OF 1
DATE 00.11.22	TITLE CROSSTUBE MATERIAL		SCALE 1:1
A	00.11.22	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
00.11.24



### NOTES

1) D6004-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 115" LONG TUBE: D6004-115

2) MATERIAL: 2.500 OD x 0.350 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.

MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi

MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:

O.D.:  $\pm 0.006$  MEAN ( $\pm 0.012$  INCLUDING OVALITY)

WALL:  $\pm 0.015$  MEAN ( $\pm 0.035$  INCLUDING ECCENTRICITY)

LENGTH: XXX  $+0.125/-0.000$

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY  
RETURN TO

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34685

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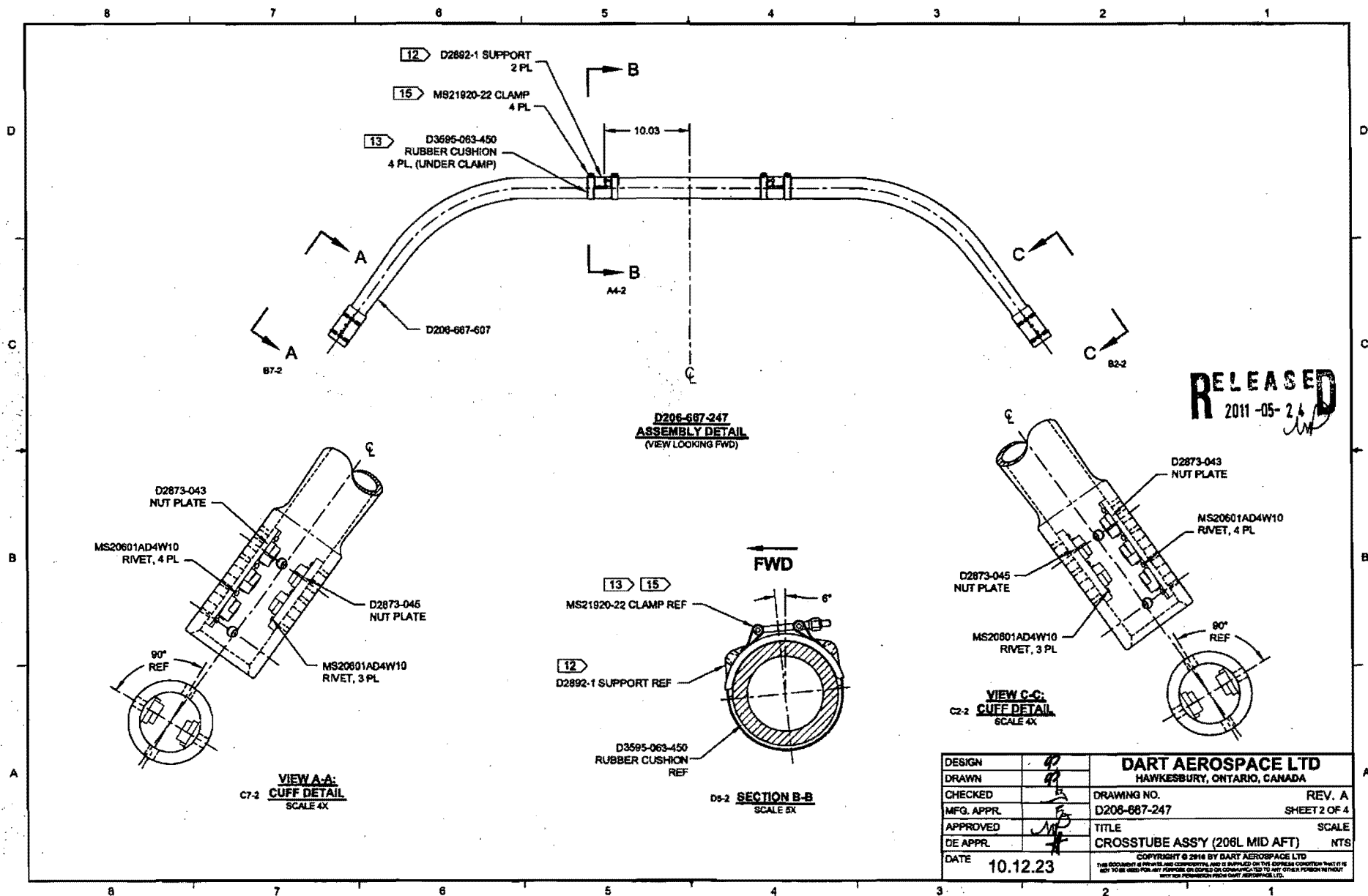
Item	Qty	Part Number	Description
	-247		
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
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4	2	D2873-045	NUT PLATE
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6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON  
INSIDE OF CLIFF PER DART QSI 044 8.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI  
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
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- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
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SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-05-24

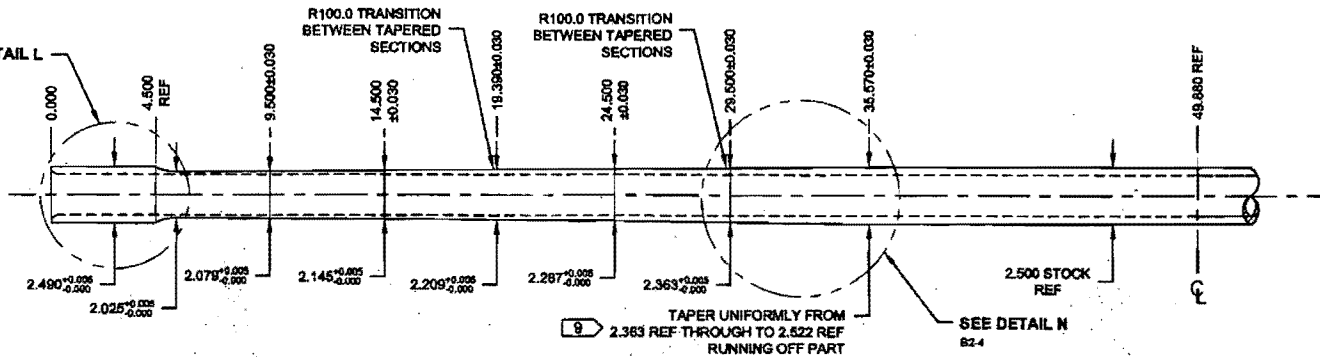
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DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D206-667-247		SHEET 1 OF 4	
APPROVED		TITLE		SCALE	
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)		NTS	
DATE	10.12.23	<small>COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			



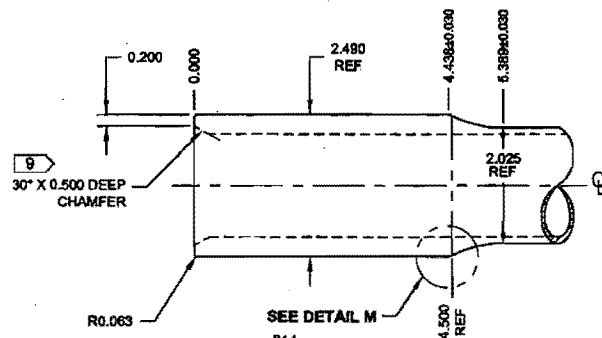




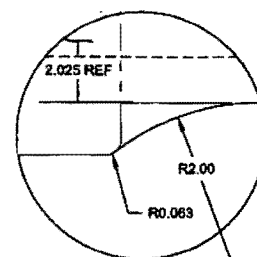
SEE DETAIL L  
B7-4



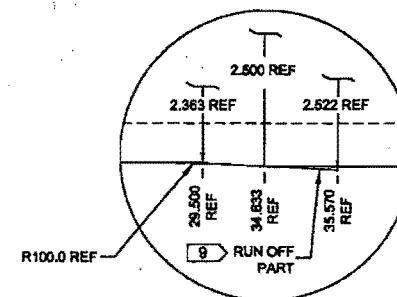
**TURNING DETAIL**



C7-4 **DETAIL L: CROSSTUBE CUFF**  
SCALE 2.5X









B8-4 **DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
2011-05-26

DESIGN		<b>DART AEROSPACE LTD</b>	
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